

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000111**Date Inspected:** 26-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lui Lui**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bid: 52, 55 Tower & Girder**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans QA inspector was present as requested by ZPMC to witness the mechanical testing for PQR HP200749 as follows:

HP200749 Submerged Arc Welding (SAW) Complete Joint Penetration Groove Weld, 1G position with Steel Backing. AWS D1.5, Section 5.13.

All Weld Metal Tension Test

Reduced Section Tension Test

Side Bend Test

Charpy-V Notch (CVN) Test

Groove Weld Macro Test

Testing performed to AWS D1.5, Section 5.16, Figure 5.1 and Table 5.5 requirements.

Caltrans assigned lot number B49-018-07.

ZPMC Quality Assurance Manager, Mr. Liu Liu submitted supporting testing documentation for review and records. The recorded test information appeared to be complete, accurate and complying with contract documents. American Bridge/Fluor Quality Control Inspector, Mr.Song Wei Min was also present during the mechanical testing. The testing records are on file at Caltrans field office for future reference. See Caltrans Welding Witness Report (TL-6032), dated March 26, 2007 for additional information.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

At 1000 hours. ZPMC Quality Assurance Inspector, Mr. Hu Gang met with Caltrans QA and stated that ZPMC would be performing mechanical for PQR HP200749 at 1300 hours. Caltrans was present at 1300 hours to witness the mechanical testing.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hasler, Mike

Quality Assurance Inspector

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**Reviewed By:** McClary, David

QA Reviewer